

633.01

27

Date: Tuesday, 6/19/2007 2:04:28 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STEP WELDMENT
Job Number	32945A		
Estimate Number	10176		
P.O. Number	N/A	Part Number	D2563
This Issue	6/19/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2563 REV C
First Issue	N/A	Project Number	N/A
Previous Run	32389A	Drawing Revision	C
Written By		Material	N/A
Checked & Approved By	<u>John</u> 07.06.20	Due Date	7/6/2007
Comment	Est Rev:G 02.07.31 Re-format Location RF	Qty:	10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2244116	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Pick: 1 D2244 Step Extrusion	
		Batch: <u>B28216</u>	<u>a.m 07.08.14</u>
2.0	D267334	End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Pick: Qty Part No. Description Batch	
		2 D2673-34 End Cap <u>B32404</u>	<u>J.E. 07.08.27</u>
3.0	D2561	Lug Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Pick: Qty Part No. Description Batch	
		2 D2561 Lug Plate <u>B32403</u>	<u>J.E. 07.08.27</u>
4.0	D2564	Mounting Angle	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Pick: Qty Part No. Description Batch	
		2 D2564 Mounting Angle <u>332460 = 13</u>	<u>J.E. 07.08.27</u>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Pick: Qty Part No. Description Batch	
		2 D2564 Mounting Angle <u>330464 = 7</u>	<u>J.E. 07.08.27</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32945A		Part Number: D2563
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut D2244 to 89.70" at 34° as per Dwg D2563 <i>a.m. 07.08.14</i> 10		
2-Deburr ends <i>SL. 07-08-21</i> 10		
3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <u>M103794</u> <i>SL 07-08-28</i> 10		
4-Grind <i>a.m. 07.08.28</i> 10		
6.0	QC5/9	WELD INSPECTION
Comment: WELD INSPECTION <i>PD 07-08-28</i> 10		
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>a.m. 07.08.29</i> 10		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>M 07.08.29</i> 10		
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Inspect for foreign object per QSI 024 <i>SL 07-08-29</i> 10		
2-Weld Remaining End as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <u>M103794</u> <i>SL 07-08-29</i> 10		
3-Grind <i>a.m. 07.08.30</i> 10		
10.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION <i>M 07/08/31</i> 10		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 5/16/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32945A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sp 07/08/31 X10

12.0 POWDER COATING

POWDER COATING



m 105068

→ fd

07/08/31 10

Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

bk

07-09-04 10

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M 105386

10X

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

m-f

07/09/04

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



PPP B34346

07/09/11 10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/10

Job Completion



✓ 07/09/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

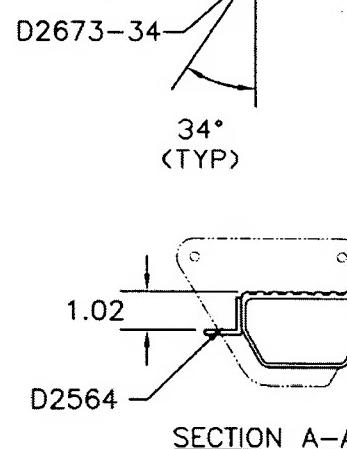
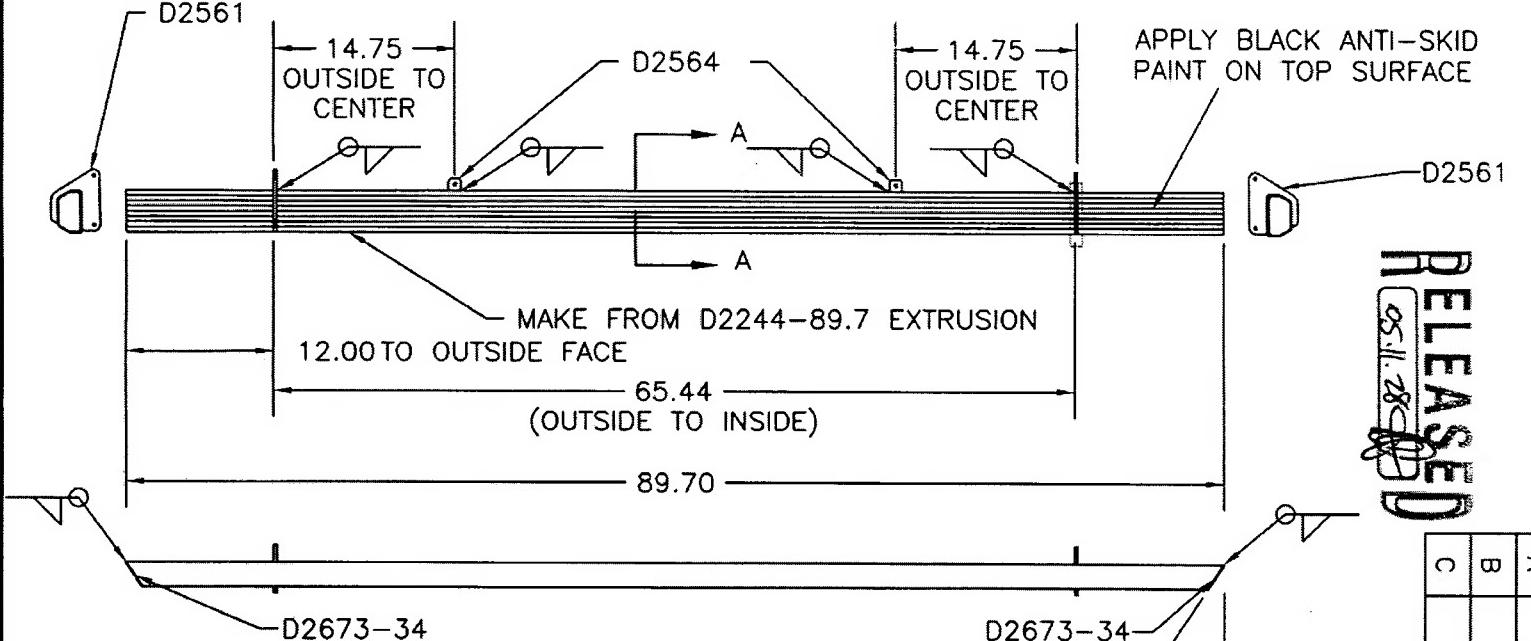
Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

UNCONTROLLED COPY
NOT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22945A

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN BW	DRAWN BY <i>PJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D2563
DATE 05.11.14	TITLE STEP WELDMENT ASSEMBLY	REV. C SHEET 1 OF 1
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES